

Date: Tuesday, 07/04/2009 10:35:04 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 47018	
Estimate Number : 12958	
P.O. Number :	Part Number : D36394
This Issue : 07/04/2009 S.O. No. :	Drawing Number : D3639 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 34541	Material :
Written By :	Due Date : 15/04/2009 Qty: 6 Um: Each
Checked & Approved By : <u>09.04.07</u>	
Comment : Est Rev:A New Issue 07-07-20 JLM	Verified By: EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S050	2024-T3 .050 sheet
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Comment: Qty.: 0.4491 sf(s)/Unit Total: 2.6945 sf(s)
 2024-T3 .050 sheet
 Batch: 111381 IB 9-4-13

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3639
 Dwg Rev: A
 Prog Rev: A

IB 9-4-13

⑨

2-Deburr if necessary IB 9-4-13

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 9-4-13**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK5 09/04/13

⑨

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Form as per Dwg D3639

53 09/04/14

⑨

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:35:04 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 47018

Part Number: D36394

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/04/15 (25)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

110

09-04-15 X9

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 04-04-15 (9)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 55262

A 09/04/15

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/15

Job Completion



mf 09-04-15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 4708
Description: Doubler		Part Number: D3639-4
Inspection Dwg: D3639	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

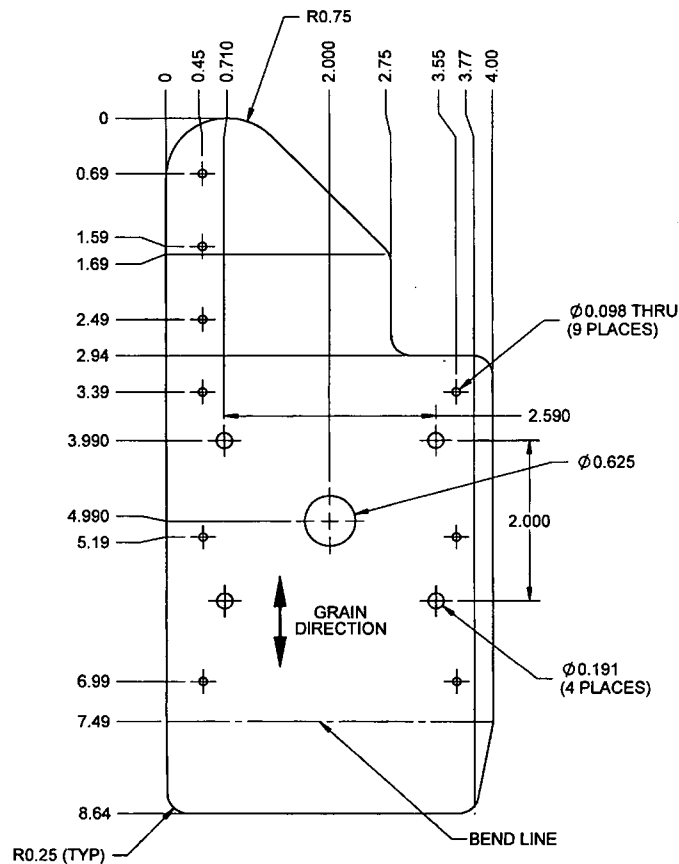
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.625	+0.008/-0.001	.626	x			
Ø0.191	+0.005/-0.001	.193	x			
Ø0.098	+0.004/-0.001	.100	x			
0.45	+/-0.030	.450	x			
1.350	+/-0.010	1.351	x			
2.25	+/-0.030	2.251	x			
3.15	+/-0.030	3.156	x			
4.05	+/-0.030	4.056	x			
4.95	+/-0.030	4.955	x			
5.85	+/-0.030	5.857	x			
6.75	+/-0.030	6.755	x			
7.65	+/-0.030	7.653	x			
8.55	+/-0.030	8.556	x			
9.350	+/-0.010	9.354	x			
9.45	+/-0.030	9.456	x			
10.350	+/-0.010	10.356	x			
11.25	+/-0.030	11.254	x			
12.15	+/-0.030	12.15	x			
12.85	+/-0.030	12.80	x			
13.86	+/-0.030	13.86	x			
13.96	+/-0.030	13.96	x			
0.805	+/-0.010	.803	x			
1.00	+/-0.030	1.002	x			
2.100	+/-0.010	2.103	x			
3.30	+/-0.030	3.30	x			
2.000	+/-0.010	2.002	x			
2.590	+/-0.010	2.593	x			

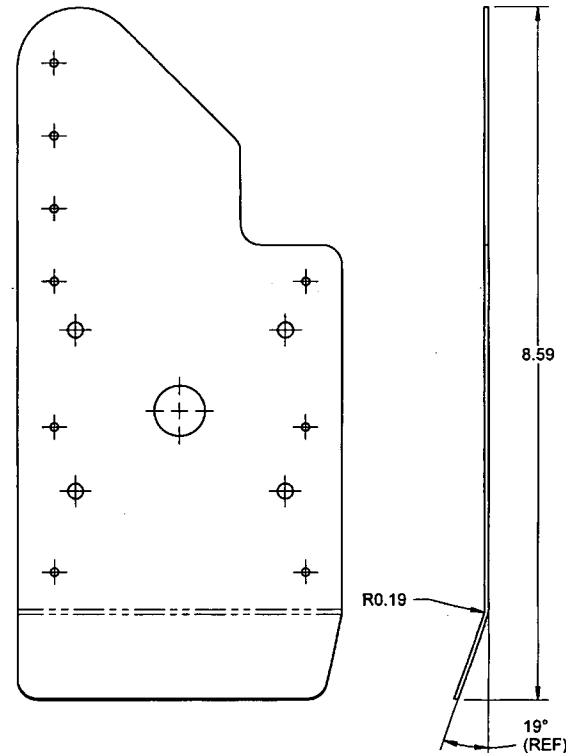
Measured by: #B	Audited by: S	Prototype Approval:	N/A
Date: 9-4-13	Date: 09/04/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.24	New Issue	KJ/EC/DD	

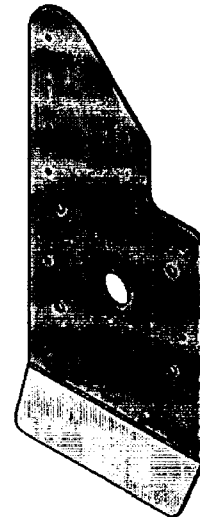
8 7 6 5 4 3 2 1



D3639-1F FLAT PATTERN
(D3639-2F OPPOSITE)



D3639-1 DOUBLER
(WAS GENEVA P/N G10604-3)
D3639-2 OPPOSITE
(WAS GENEVA P/N G10604-6)



RELEASED
07.07.27

NOTES:

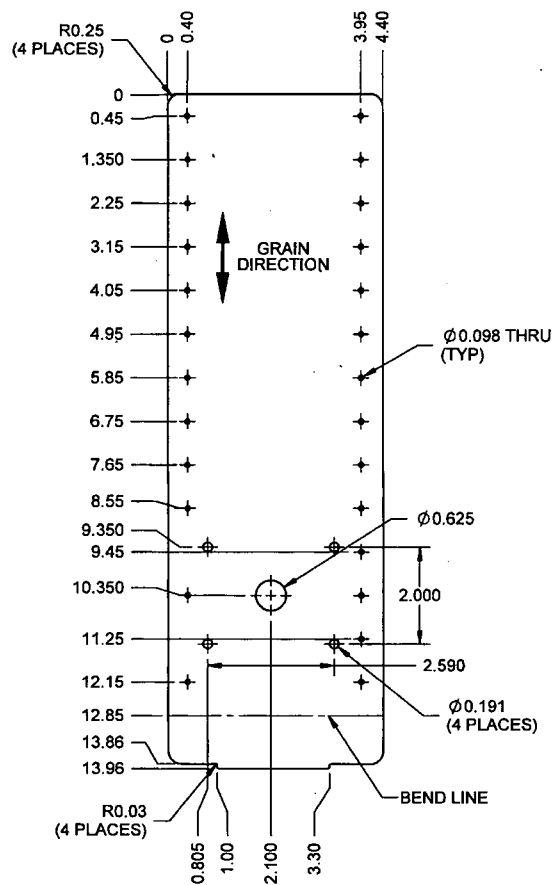
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-1/-2" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.100 LBS

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE; REPLACES G10604	LE	07.07.27
DESIGN	IS		
DRAWN	LE		
CHECKED	LE		
MFG. APPR.	LE		
APPROVED	LE		
DE APPR.	LE		
DATE	07.07.27		

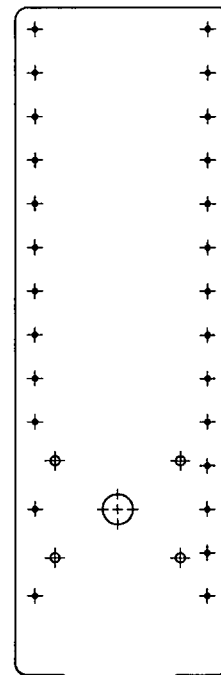
DART AEROSPACE USA, INC.
PORT HADLOCK, WA
DRAWING NO. **D3639**
REV. A
SHEET 1 OF 2
TITLE **DOUBLER**
SCALE 2:3

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WORK ORDER



D3639-3F FLAT PATTERN
(D3639-4F OPPOSITE)



D3639-3 DOUBLER
(WAS GENEVA P/N G10604-4)
D3639-4 OPPOSITE
(WAS GENEVA P/N G10604-5)

RELEASED
07.09.07

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-3/-4" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.34

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	LE	PORT HADLOCK, WA	
CHECKED	LE	DRAWING NO.	REV. A
MFG. APPR.	LE	D3639	SHEET 2 OF 2
APPROVED	LE	TITLE	SCALE
DE APPR.	LE	DOUBLER	2:5
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